

Work Order ID 120324

120324

Page 1

September-16-14 12:38:16 PM

Item ID: D4353-041 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bearpaw Assembly
 Start Date: 6/04/14 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 6/04/14 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4353	B

105		0.00							
105									
Purchasing	Memo	0.00							
Purchasing	ISSUE PO <u>25836</u>								
	Cut Blank per D4353-1 file								

OK 14/10/18 2

110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	0.00							
Packaging									

OK 14/10/01 (2)

115	QC6- Inspect dimensions to drawing	0.00							
115									
QC	Memo	0.00							
Quality Control									

OK 14/10/25 2

Work Order ID 120324***120324***

Page 2

Item ID: D4353-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bearpaw Assembly
Start Date: 6/04/14 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 6/04/14 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* HAAS 1 HAAS CNC vertical machine #1	HAAS CNC VERTICAL MACHINING #1 Memo 1-Inspect material for defects or damage prior to machining 2-Machine as per FolioFB050 and Dwg FOLIO REV: <u>B</u> DWG REV: <u>AA</u> 3-Deburr	0.00 0.00				<u>2</u>	<u>0</u>		
140 *140* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				<u>2</u>	<u>0</u>		
150 *150* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				<u>2</u>	<u>0</u>		DAS 08 9-88

Work Order ID 120324

120324

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September-16-14 12:38:16 PM

Item ID: D4353-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bearpaw Assembly
 Start Date: 6/04/14 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 6/04/14 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
155	Identify as per dwg & Stock Location: _____	0.00							
155									
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

NOV 19 2014

030
12
046

125/88 2

14/11/17

4-11-19

Picklist Print

Wednesday, June 04, 2014 3:02:02 PM

Page 1

Work Order ID: 120324

120324

Parent Item: D4353-041

D4353-041

Parent Item Name: Bearpaw Assembly

Start Date: 6/04/14

Required Date: 6/04/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 11-04-12 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased					sf	774.0000		13			

MUHMWB10

UHMW 1" Black - 48"x120" Tivar Mfg.#52480104

**

C214110/03

Location

Loc Qty

Loc Code

MAT

400

m129293

400

MAT018

374

m128267

47

m128668

327

m130421 x13

D4353-3

Manufactured No

Each

9.0000

2

D4353-3

Bearpaw Insert

**

14/11/04

DAS
36
9-88

Location

Loc Qty

Loc Code

ST104

9

70727

1

80241

2

81711

6

B124862

(2x)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:25%;">Skid-tube <input type="checkbox"/></td> <td style="width:25%;">Crosstube <input type="checkbox"/></td> <td style="width:25%;">Water Jet <input type="checkbox"/></td> <td style="width:25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
--	--	---	--

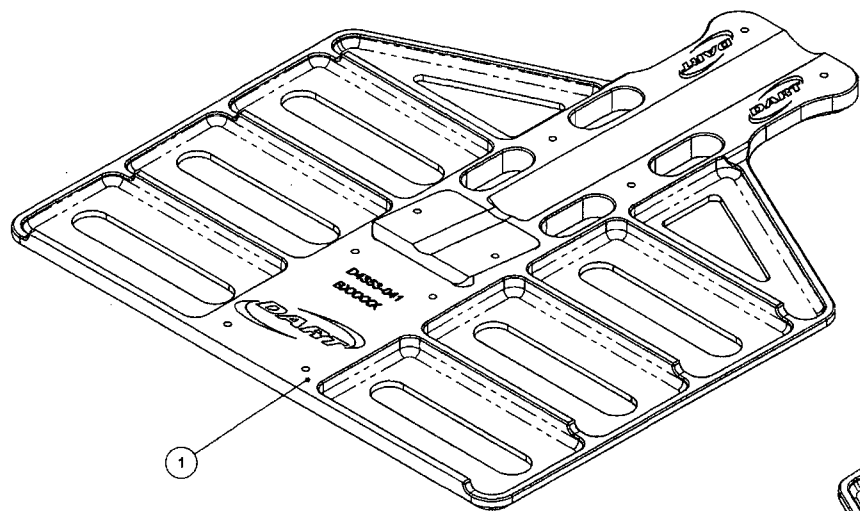
DART AEROSPACE LTD		Work Order:	120324
Description: Bearpaw		Part Number:	D4353-1
Inspection Dwg: D4353	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

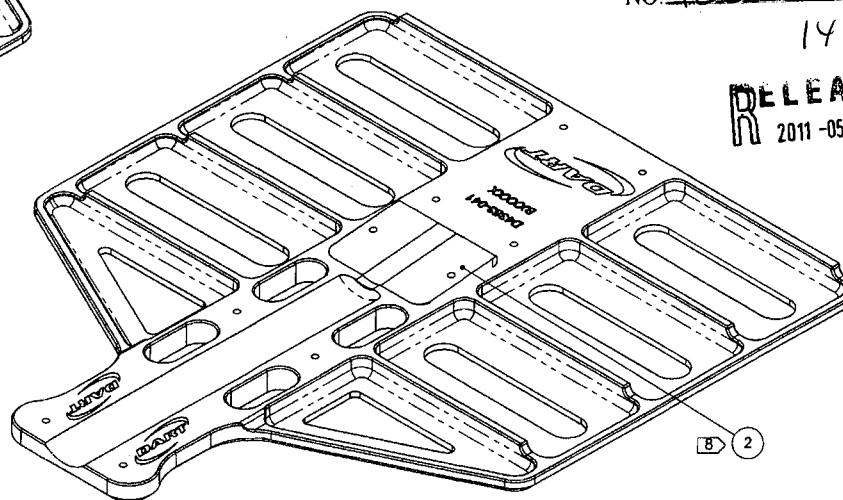
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.38	+/-0.030	380	✓		Vern	ML-06
7.375	+/-0.010	7.375	✓		M-tape	ML-08
12.50	+/-0.030	12.500	✓		"	
1.38	+/-0.030	1.360	✓		Vern	ML-06
3.813	+/-0.010	3.813	✓		"	
24.00	+/-0.030	24.000	✓		M-tape	ML-08
10.09	+/-0.030	10.090	✓		"	
1.00	+/-0.030	1.000	✓		Vern	ML-06
6.150	+/-0.010	6.150	✓		"	
3.038	+/-0.010	3.038	✓		"	
6.563	+/-0.010	6.563	✓		"	
9.250	+/-0.010	9.250	✓		M-tape	ML-08
27.00	+/-0.030	27.000	✓		"	
1.25	+/-0.030	1.250	✓		Vern	ML-06
0.30 x 45°	+/-0.030	.270x45°	✓		"	
1.38	+/-0.030	1.380	✓		"	
0.63	+/-0.030	.620	✓		"	
0.95	+/-0.030	.945	✓		"	
R0.25	+/-0.030	R.250	✓		"	
0.70	+/-0.030	.700	✓		"	
0.07 x 45°	+/-0.030	.040x45°	✓		"	
Ø0.650	+/-0.010	Ø.650	✓		"	
Ø0.261	+0.006/-0.001	Ø.260	✓		"	
0.400	+/-0.010	.405	✓		"	
4.750	+0.012/-0.000	4.750	✓		"	
4.000	+0.012/-0.000	4.000	✓		"	
5.75	+/-0.030	5.753	✓		"	
0.63	+/-0.030	.620	✓		"	
0.57	+/-0.030	.571	✓		"	
0.25	+/-0.030	.245	✓		"	
0.45	+/-0.030	.445	✓		"	
0.06 x 45°	+/-0.030	.040x45°	✓		"	
R0.25	+/-0.030	R.250	✓		"	

Measured by:	<i>[Signature]</i>	Audited by:	<i>[Signature]</i>	DAS	Preliminary Approval:	
Date:	14/10/25	Date:	14/10/30	08 9-89	Date:	

Rev	Date	Change	Revised by	Approved
A	11.07.26	New Issue	KJ	<i>[Signature]</i>




D4353-041 429 BEARPAW ASSEMBLY







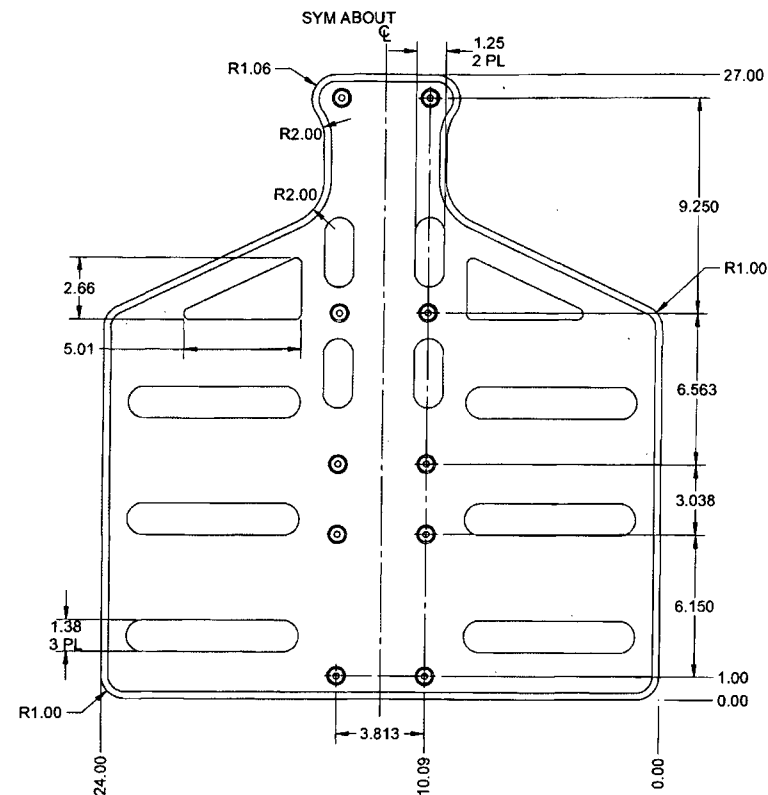
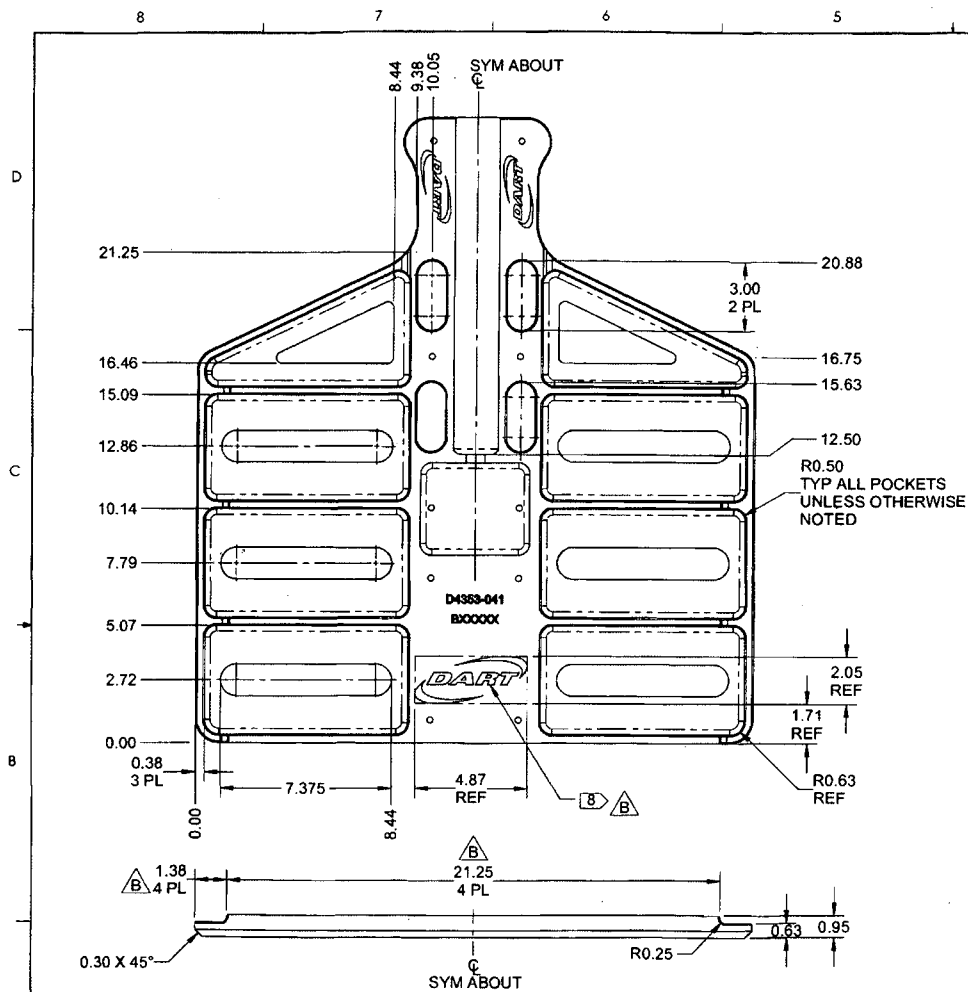
ITEM	QTY	P/N	DESCRIPTION
	X	D4353-041	429 BEARPAW ASSEMBLY
1	1	D4353-1	429 BEARPAW
2	1	D4353-3	429 BEARPAW INSERT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 120324 MJS
1406-06

RELEASED
2011-05-25
MD

- NOTES:**
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: 7.45 lbs
8) PRESS FIT 

B	SHT 1 WEIGHT CORRECTED WAS 8.24 lbs. SHTS 1-3 DART LOGOS UPDATED. SHT 2, ZONE B8, AFT POCKET REDUCED. RIB INCREASED IN HEIGHT. SHT 3 SECTS. B,C & D RIB INCREASED IN HEIGHT.	AJS	11.04.28
A	NEW ISSUE	AJS	11.03.24
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	AJS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.04.26		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4353 TITLE 429 BEARPAW ASSEMBLY SCALE NTS REV. B SHEET 1 OF 4 COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



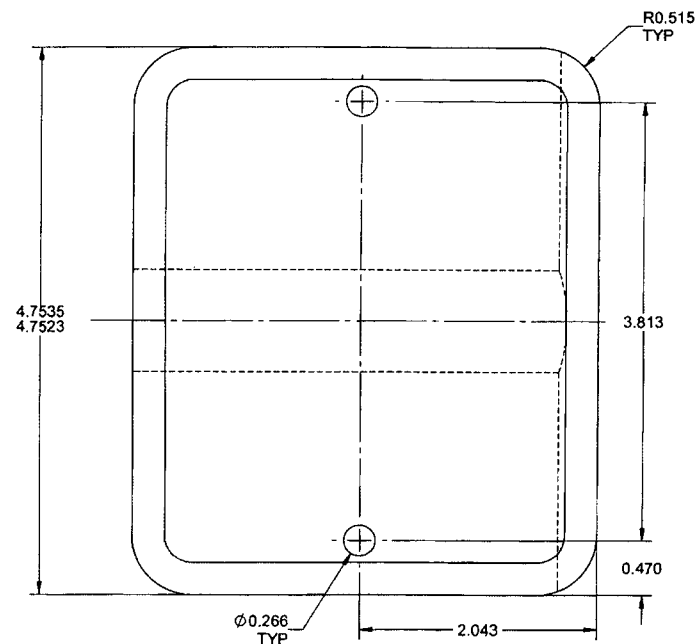
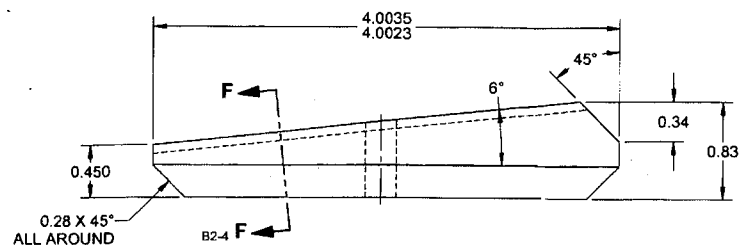
D4353-1 429 BEARPAW

RELEASED
2011-05-04

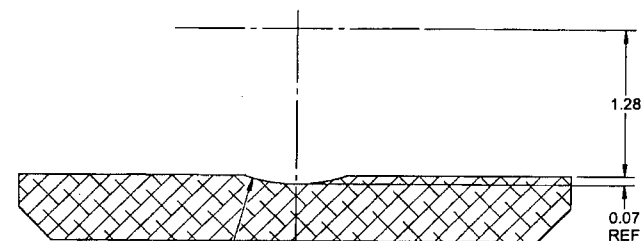
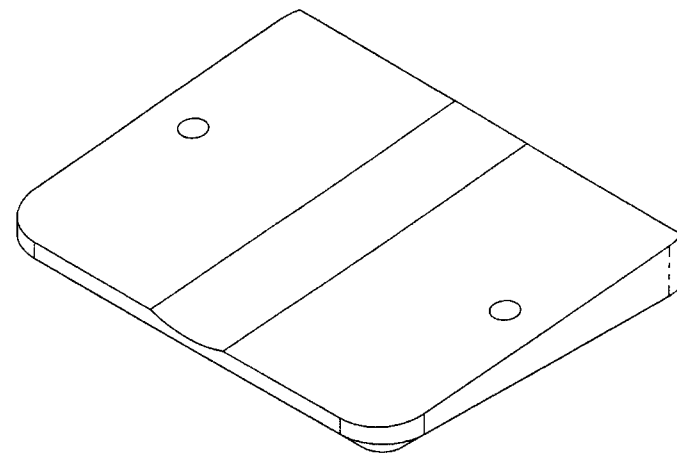
NOTES:

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.000 THICK.
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: ENGRAVE WITH DART ASSEMBLY P/N "D4353-041" AND B/N "BXXXXX" 0.005 - 0.010 DP AS SHOWN
- 7) WEIGHT: 7.07 lbs
- 8) ENGRAVE "DART" LOGO AS SHOWN 0.003 - 0.005 DP.

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4353	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	429 BEARPAW ASSEMBLY	NTS
DATE	11.04.26	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
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D4353-3 429 BEARPAW INSERT



SECTION F-F C7-4

RELEASED
2011-05-24

NOTES:

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.000 THICK.
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.38 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4353	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	429 BEARPAW ASSEMBLY	NTS
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T.P.I. INDUSTRIES INC.

148 GOODFELLOW
DELSON, QUÉBEC J5B 1V4
CANADA
Tel: (450) 633-0484
Fax: (450) 633-0879

Packing Slip

Packing Slip No.: 6316
Date: 2014-09-29
Page: 1

Sold to:	Ship to:
Dart Aerospace Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada	Dart Aerospace Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada
Order No.: 100810	Sold By: JONATHAN LESSARD
Shipped By:	Ship Date: 2014-09-29
Tracking No.:	

Item No.	Unit	Description	Quantity
d2432-3	Chaque	d2432-3 bearpaw	2
d2435	Chaque	d2435 bearpaw	18
d2521	Chaque	d2521 bearpaw	22
d2432	Chaque	d2432 bearpaw	15
d4930-1	Chaque	d4930-1 bearpaw	8
d4355-1	Chaque	d4355-1 bearpaw	7
d4353-041	Chaque	d4353-041 bearpaw	2
d4297-1	Chaque	d4297-1 bearpaw	2
d2995	Chaque	d2995 bearpaw	2
		po 25686	
Comment: Des frais d'intérêts de 2% / mois seront chargés sur tout compte passé du après 30 jours			